

Date: Thursday, 10/04/2008 10:36:49 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CABIN FLOOR PROTECTOR		
Job Number	: 38513			Part Number	: D35742		
Estimate Number	: 12661			Drawing Number	: D3574 REV.A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/04/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: 10/04/2008 Type : SMALL /MED FAB			Due Date	: 18/04/2008 Qty: 4 Um: Each		
Previous Run	: 37644						
Written By	:						
Checked & Approved By	: <u>SD 08-4-10</u>						
Comment	: Est Rev :A New Issue 07-01-22 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F60029 mLexS125F6002904	lexan grey
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108/04/11



MAT. NOT PULLED



Comment: Qty.: 32.0000 sf(s)/Unit Total : 128.0000 sf(s)

F60029 lexan sheet

Batch: 103106

HB 8-4-11

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3574

Dwg Rev: A

Prog Rev: A

HB 8-4-11

(4)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-4-11

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SD 08/04/11

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SD 08/04/11 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/04/2008 10:36:50 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 38513

Part Number: D35742

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/15 (X4)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: 100 38511 81116 SP ✓

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/16 JJ

Job Completion



-MF 08-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

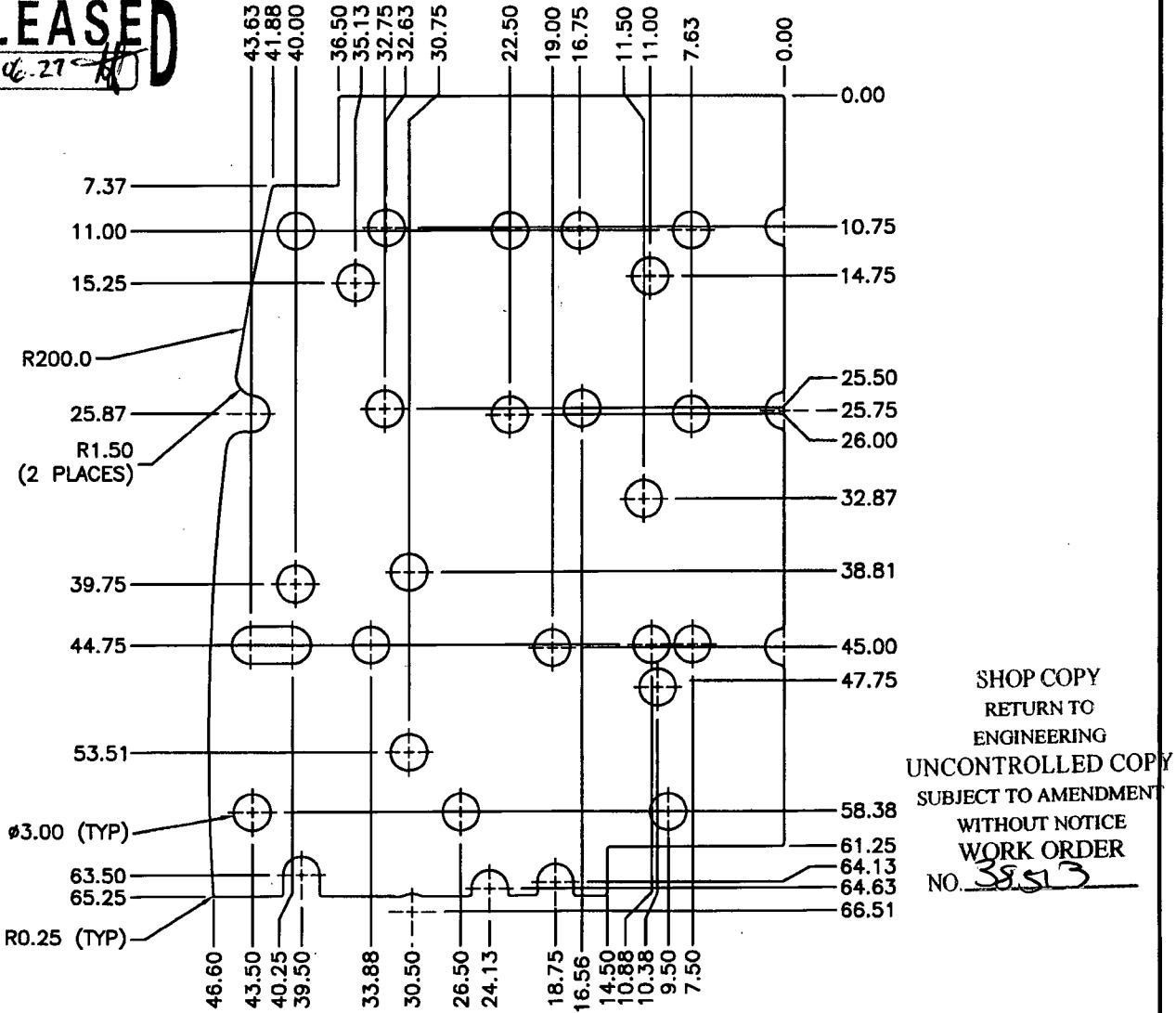
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07-06-27 *[Signature]*



D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)

NOTES:

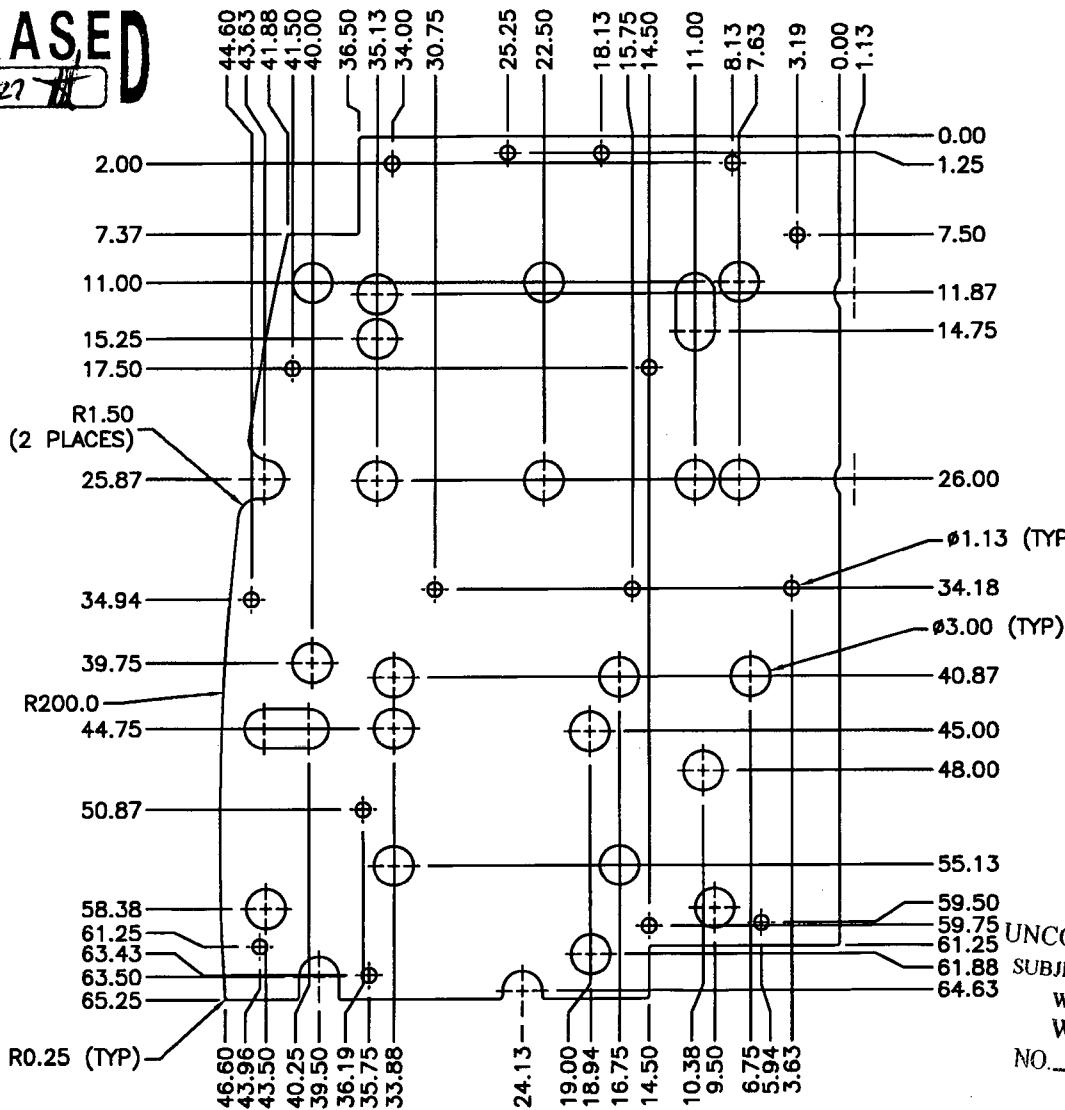
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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CHECKED <i>CE</i>	APPROVED <i>-H</i>	DRAWING NO. D3574	REV. A SHEET 2 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.08**D3574-3 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

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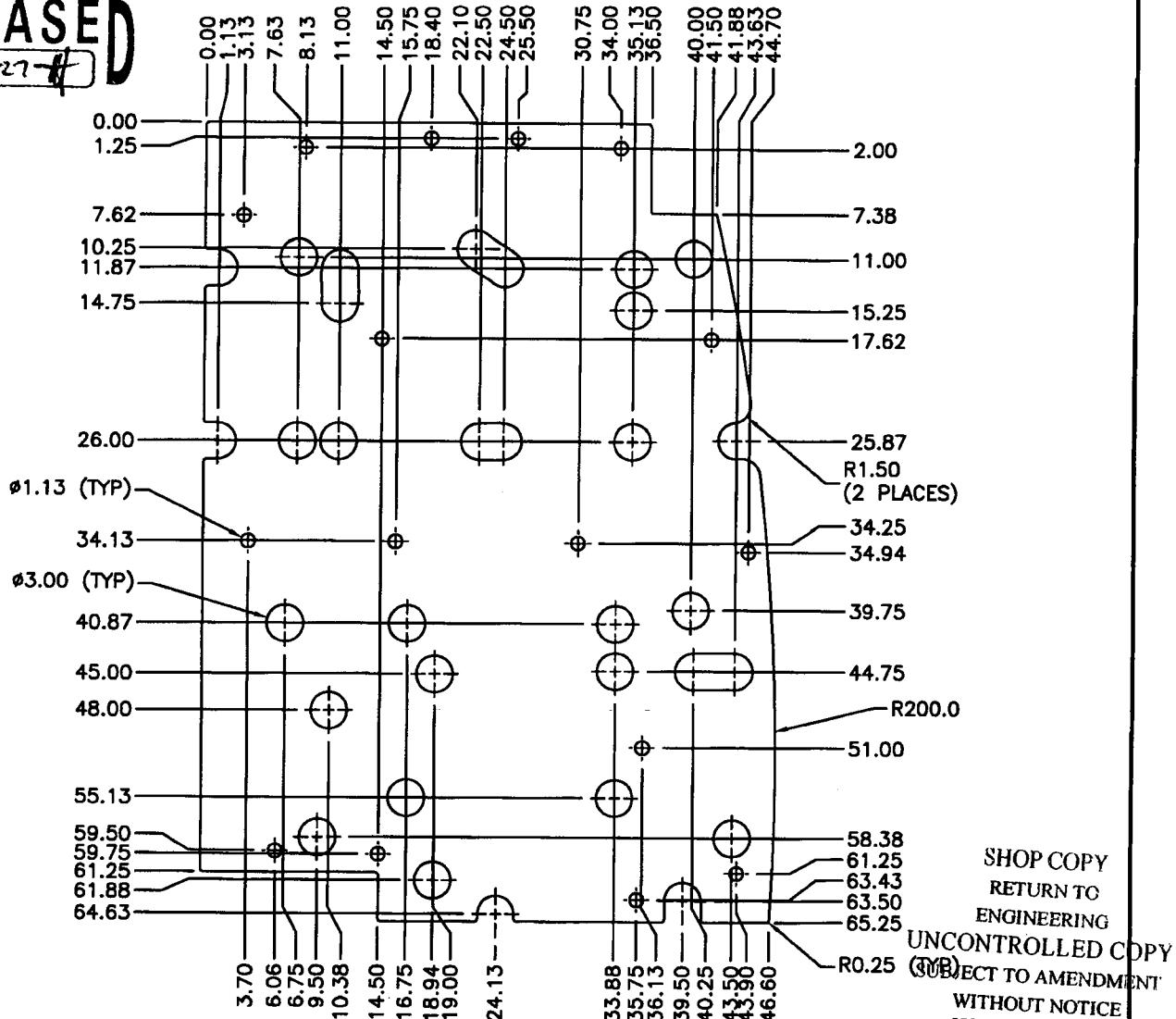
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CHECKED <i>CE</i>	APPROVED <i>SH</i>	DRAWING NO. D3574	REV. A	SHEET 3 OF 5
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14	

RELEASED
07.06.27-#

07.06.27-#



D3574-4 CABIN FLOOR PROTECTOR

NOTES:

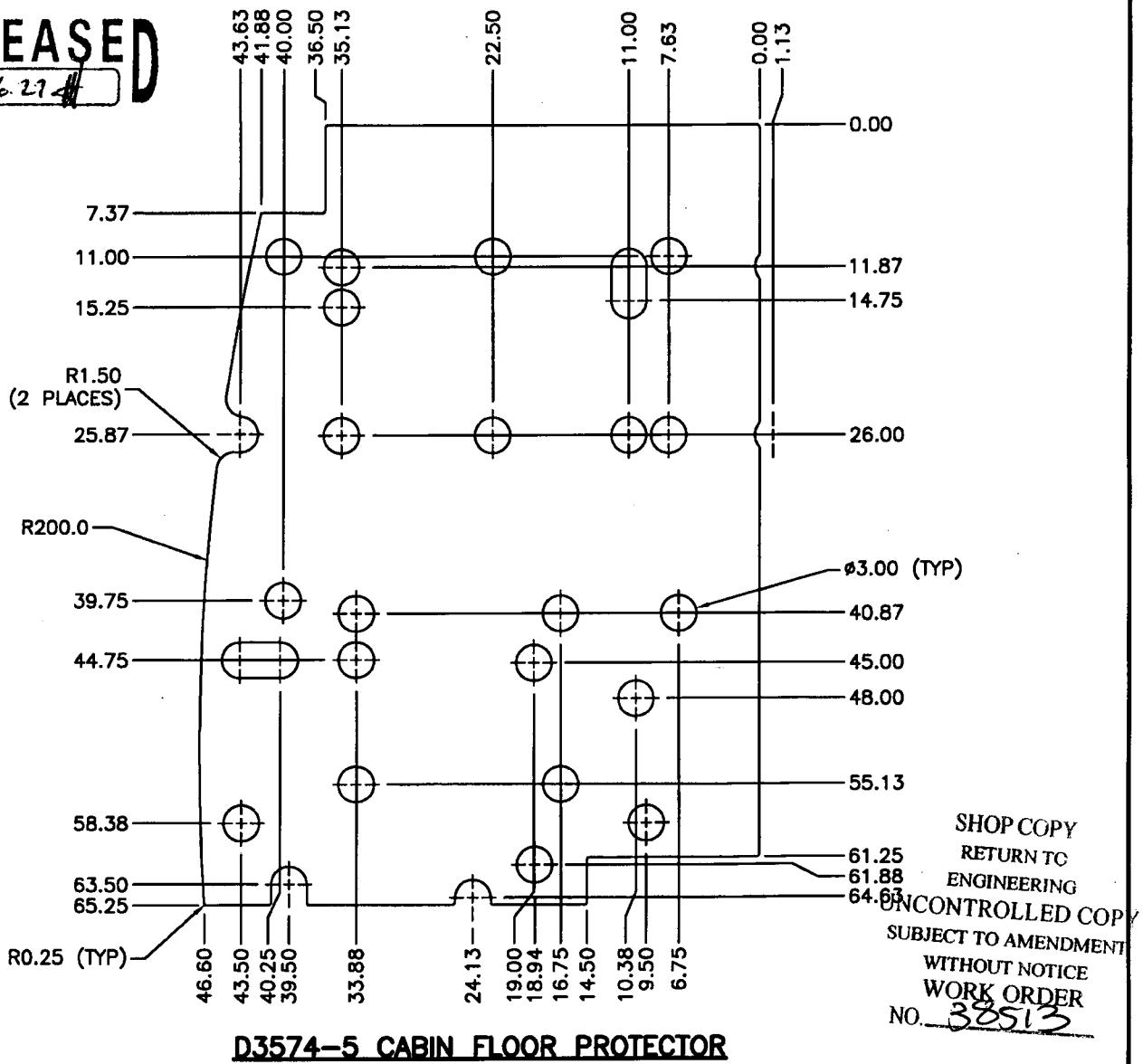
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
(SUBJECT TO AMENDMENT)
WITHOUT NOTICE
WORK ORDER
NO. 58513

DART

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CHECKED <i>CE</i>	APPROVED <i>HT</i>	DRAWING NO. D3574	REV. A SHEET 4 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.21**NOTES:**

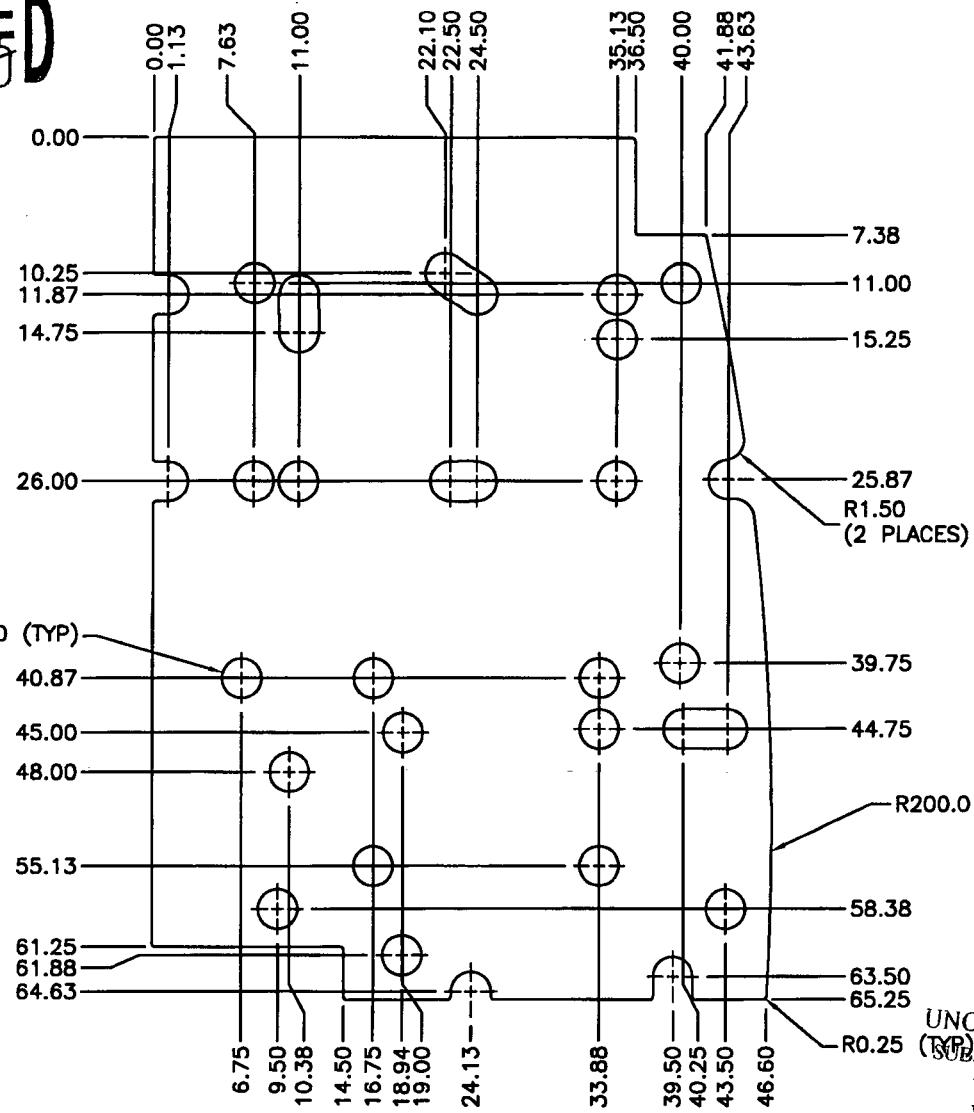
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

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CHECKED <i>CE</i>	APPROVED <i>JK</i>	DRAWING NO. D3574	REV. A SHEET 5 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.08**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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DART AEROSPACE LTD

Work Order:

38512

Description: CABIN FLOOR PROTECTOR

Part Number:

D3574-2

Inspection Dwg: D3574-1 Rev: A

Page 1 of 3

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.00	+ .012 - .001	3.002 *				
7.37	+/- .030	7.37 *				
11.00	+/- .030	11.00 *				
15.25	+/- .030	15.25 *				
39.75	+/- .030	39.75 *				
44.75	+/- .030	44.75 *				
53.51	+/- .030	53.51 *				
63.50	+/- .030	63.50 *				
65.25	+/- .030	65.25 *				
10.75	+/- .030	10.75 *				
14.75	+/- .030	14.75 *				
25.50	+/- .030	25.50 *				
25.75	+/- .030	25.75 *				
26.00	+/- .030	26.00 *				
32.87	+/- .030	32.87 *				
38.81	+/- .030	38.81 *				
45.00	+/- .030	45.00 *				
58.38	+/- .030	58.38 *				
61.25	+/- .030	61.25 *				
64.13	+/- .030	64.13 *				
64.63	+/- .030	64.63 *				

Measured by: HB

Audited by: S

Prototype Approval: Date: 1/17

Date: 8-4-11

Date: 02/04/14

Date: 1/17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

HB

8-4-11

DART AEROSPACE LTD

Work Order:

38512

Description: CABIN FLOOR PROTECTOR

Part Number:

D3574-2

Inspection Dwg: D3574-1 Rev: A

Page 2 of 3

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.50	+/- .030	7.50				
9.50	+/- .030	9.50				
10.38	+/- .036	10.38				
10.88	+/- .030	10.88				
14.50	+/- .030	14.50				
16.56	+/- .030	16.56				
18.75	+/- .030	18.75				
24.13	+/- .030	24.13				
26.56	+/- .030	26.56				
33.88	+/- .030	33.88				
39.50	+/- .030	39.50				
40.25	+/- .030	40.25				
43.50	+/- .030	43.50				
46.60	+/- .030	46.60				
7.63	+/- .030	7.63				
11.00	+/- .030	11.00				
11.50	+/- .030	11.50				
16.75	+/- .030	16.75				
19.00	+/- .030	19.00				
22.50	+/- .030	22.50				
30.75	+/- .030	30.75				
32.63	+/- .030	32.63				
33.75	+/- .030	33.75				

Measured by:

HB

Date:

8-4-11

Audited by:

J

Date:

08/04/14

Prototype Approval:

N/

Date:

Rev

Date

Change

Revised by

Approved

A

New Issue

KJ/JLM

HB
8-4-11

J

CART AEROSPACE LTD	Work Order:	38512
Description: CABIN FLOOR PROTECTOR	Part Number:	D3574-2
Inspection Dwg: D3574-1 Rev: A		Page 3 of 13

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>LB</u>	Audited by: <u>b</u>	Prototype Approval: <u>n</u>
Date: <u>8-4-11</u>	Date: <u>09/04/14</u>	Date: <u>4</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8-4-1

10